	Wh	rk	Orde	r ID	108920
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## \*108920\*

Page 1

October-29-13 10:18:27 AM Accept \*N900040100\* Item ID: D2161-205 Setup Start **Revision ID:** Mirror Bracket, 205 Item Name: 10/29/13 Start Oty: 2.00 Start Date: **Cust Item ID:** Required Date: 10/29/13 **Req'd Qty:** 2.00 **Customer:** Reference: Run Process Plan: 415 Date: 13-10-29 Tooling: Date: Approvals: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Sequence ID/ Number Stamp **Run Hours Qty** Qty Work Center ID Description Code **Revision Nbr Draw Nbr** Rev B2 D2161 0.00 100 2 @ 13-11-11 Large Fab \*100\* 0.00 Large Fab Memo 1-Assemble on Jig DT8065 as per Dwg D2161 Large Fab 2-Weld as per Dwg D2161 Identify as D2161-205 QC9- Inspect visual per QSI004- Fusion Welds 0.00 D 13-11-11 09 \*110\* OC 0.00 Memo Quality Control

120

QC5- Inspect part completeness to step on W/O 0.00

\*120\* QC

Quality Control

Memo

0.00

@ 13-11-11 DAS

DQA:	<del></del>	Date:			- WORK ORDER MON CONTROLLING (1175 175									TRACE"
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	AEROSPACE						
			-		DISPOSITION									
Work Orde	er:				<u></u>	,								
					Rework		Skid-tube Crosstube Water Jet							Engineering
Part I	NO				Scrap			Machining	Small Fab	_		d. Eng. Coor.	<u> </u>	Quality
NCR I	No.				Use-as-is		Thern	noforming	Finishing					Other
INCK I	<b>V</b> O.	·			Suspected Unapproved	1		Large Fab	Composite	e Supplier				
Root				Desc	ription of work order update		Initial	Act	ion	T	Sign &		_	
Cause	Date	Step	Qty		or non-conformance	· I					Date Verification			QC Inspector
Design										$\dashv$				
Doc/Data			İ									:		
Equip/Tooling				<u> </u>										
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training			l										:	
Transport							-*			1				
Unapproved												·	1	
						FAI	ULT CAT	EGORY						
Landi	ng Gear				General						-			
	Bendin	g			Bend		Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain		Ī		ver/Under	tolerance	Г	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re	Ī	P	art Incorrec	ct .	i	Temperature/Cure
	Crimp/	Kink/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified	P	art Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	ions Incomplete/L	Jnclear	P	art Moved	-	$\Box$	Wrong Stock Pulled
	Crushii	ng			Countersink		Misalig	ned/off center	Ī	Πp	ositioned W	ا Vrong		Ü
Heat Treat					Cut Too Short		Mislabe			_	ower Loss/S			Other
	Inspec	ion Strip in	Tube		Drawing		Misread	I			·	· [	_	-
	Marks	Chatter Charter			Drill Holes		Off-set			_			-	
	Turnin	g Sequence			Finish		Out of (	Calibration		. —				
	Wave/	Twist in Tul	e		Fit/Function		Out of S	equence		_				

Work Order ID 108920 \*108920\* October-29-13 10:18:27 AM Accept \*N900040100\* Item ID: D2161-205 Setup Start **Revision ID:** Stop Mirror Bracket, 205 Item Name: Start Qty: 2.00 10/29/13 **Cust Item ID:** Start Date: Required Date: 10/29/13 **Reg'd Oty: 2.00 Customer:** Reference: Run Process Plan: Date: Tooling: Date: Approvals: Stop QC: \_\_\_\_\_ Date: SPC (Y/N): Date: Reject Operation Tool ID Tool # Plan Accept Reject Insp. Set Up/ Sequence ID/ Qty Number Stamp Code **Oty** Work Center ID Description **Run Hours** Black Sandtex(Ref.4.3.5.7) per QSI005 4.3 0.00 130 13-11-20 \*130\* 0.00 Powdercoat Memo START TIME: X CV Powder Coating FINISH TIME: DAS 27 0.00 QC3- Inspect Part Finish \*140\* QC Memo Quality Control

150

\*150\*

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

DAS

9-89

DQA:			Date:	4 )/(\)									DART			
م دامینا،			Data			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only										
QA Closed:			Date:				_				W	ork Order up	date only			
Work Orde	disposition Against department/process															
	-				_	Rework	1		Skid-tube	Crosstube			Water Jet	Engineering		
Part N	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality		
			<del>.</del> ,			Use-as-is			noforming	Finishing	<b></b>	i	Other			
NCR I	No					Suspected Unapproved			Large Fab	Composite						
Root		-			Doss	rintian of work order undate										
Cause				O+1/	Desci	ription of work order update or non-conformance	l	nitial		tion		Sign &	Vanifiaation	OC Increases		
		Jale	Step	Qty		or non-conformance	Cn	ief Eng	Desc	ription		Date	Verification	QC Inspector		
Design Doc/Data																
Equip/Tooling																
Handling/Pre	Н				•											
Material	H															
Operator																
Offset/Setup	H															
Process	Н															
Supplier	H															
Training	H															
Transport																
Unapproved																
							FAL	JLT CAT	EGORY			l				
Landi	ng Gea	r				General						-				
	Bei	nding				Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced		
	Cei	ntre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up		
	Cracks					Broken/Damage/Defect		Hardwa	re			Part Incorred	rt –	Temperature/Cure		
	Crimp/Kink/Ripple/Wave					Burrs		Inspecti	on Incomplete/U	nqualified		Part Lost/Mi	ssing	Weld		
	Cuffs					Contamination		Instruct	ions Incomplete/	Unclear		Part Moved		Wrong Stock Pulled		
	Crushing					Countersink		Misalig	ned/off center			Positioned W	/rong			
	Не	at Treat	t			Cut Too Short		Mislabe	led			Power Loss/	Surge	Other		
	Ins	pection	Strip in	Tube		Drawing		Misread	I							
	_	rks/Ch				Drill Holes		Off-set								
	-	-	equence			Finish		Out of C	Calibration							
	Wave/Twist in Tube					Fit/Function	1	Out of S	equence							

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

	Order ID	100040
14/A 14/2	I I WALAN I I I	11180711
VV: III K	<b> </b>	しいハフムリ

Page 3

October-29-13 10:18:27 AM

Required Date: 10/29/13

Item ID:

**Revision ID:** 

D2161-205

Mirror Bracket, 205

Accept

\*N900040100\*

Setup Start

Item Name: Start Date:

10/29/13

Start Qty: 2.00 Reg'd Oty: 2.00

Date:

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

QC:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Stop

Sequence ID/ Work Center ID Operation **Description**  Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Qty.

Reject Reject

Insp. Number Stamp

160 \*160\*

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

2m 13/11/20

DQA:		. Date:											****	TO A C	
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only										
Work Orde	er:				DISPOSITION AGAINST DEPARTMENT/PROCESS										
					Rework	Rework Skid-tube Crosstube Water Jet							] (	Engineering	ı
Part N	١٥.				Scrap		1	Machining	Small Fab Prod. Eng. Coor.					Quality	į
					Use-as-is		Thern	noforming	Finishing	ing Rec/Store/Packaging				Other	
NCR N	No				Suspected Unapproved			Large Fab	Composite	ite Supplier					
Root		1		Desci	ription of work order update	i	Initial	Act	ion		Sign &		<u> </u>		_
Cause	Date	Step	Qty		or non-conformance				ription		Date	Verification		QC Inspector	
Design						<b></b>									$\exists$
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material				1											
Operator				<b>.</b>		i									
Offset/Setup						1									
Process						1									ŀ
Supplier															
Training			Ė			1		!							
Transport					·					ŀ	İ				
Unapproved															
						FAI	ULT CAT	EGORY		L	·	***			
Landi	ng Gear				General										
	Bending				Bend		Folio/P	rogram			outside Dime	ensions	Pro	essure/Forced	
	Centre No	ot Concer	ntric		BOM/Route		Grain		Ī		ver/Under	tolerance	Se	t-up	
	Cracks				Broken/Damage/Defect		Hardwa	re		Р	art Incorrec	rt -	Tе	mperature/Cure	
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified	P	art Lost/Mis	ssing	T <sub>w</sub>	eld	
	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear	P	art Moved	ļ	$\neg$ w	rong Stock Pulled	
ļ	Crushing				Countersink		Misalig	ned/off center		P	ositioned W	/rong			
ļ	Heat Trea	it			Cut Too Short		Mislabe	led		P	ower Loss/S	Surge	Ot	her	j
	Inspectio	n Strip in	Tube		Drawing		Misread		-			<u> </u>			$\neg$
ļ	Marks/Ch	atter			Drill Holes		Off-set							-	$\dashv$
	Turning S	equence			Finish		Out of 0	Calibration							ᅦ
	Wave/Tw	ist in Tub	e		Fit/Function		Out of S	equence							$\dashv$

October-29-13 10:18:26 AM

Work Order ID:

108920

D2161-205

Parent Item:
Parent Item Name:

Mirror Bracket, 205

**Start Date:** 10/29/13

Required Date: 10/29/13

Start Qty: 2.00

Required Qty: 2.00

Comments:	IPP Rev:A New	Issue 05-11-01	JLM										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2013-1 Mirror Bracket LH, 205		Manufactured	No			100	Each	4.0000	1	12 2/	3 -11 -1	1	
				<u>Location</u> WA001		Loc Oty 4	<u>Lo</u>	c Code					
D2013-2 Mirror Bracket RH, 205		Manufactured	No	C107	7387	100	Each	4.0000	1	2 12 <sup>2</sup> /	3-//-1	<u> </u>	
				Location WA001		Loc Qty	<u>Lo</u>	c Code					
D2037-101		Manufactured	No	107	3339	100	Each	7.0000	1	<b>→</b>			÷ .
Arm		Manaractured		Location		Loc Qty	Lo	oc Code	6.6	[A ]	3-11-11		
				WA001	2480	7				2			

DQA:		_ Date:														
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order undate only  Work Order undate only											
QA Closeu.		Date.					Work Order update only									
Work Orde	er:				DISPOSITION	AGAINST DEPARTMENT/PROCESS										
					Rework		ļ	Skid-tube Crosstu	be	1	Water Jet	Engineering				
Part N	No				Scrap			Machining Small F		Pro	d. Eng. Coor.	Quality				
	•				Use-as-is		Thern	noforming Finishi	ng	4	e/Packaging	Other				
NCR 1	No	_			Suspected Unapproved		1	Large Fab Compos	ite 🗌	]						
	<u> </u>		· · · · ·			,						:				
Root		<b>.</b>		Descr	ription of work order update	1	Initial	Action		Sign &		- 				
Cause	Date	Step	Qty		or non-conformance	Cr	nief Eng	Description	_	Date	Verification	QC Inspector				
Design	-															
Doc/Data		į														
Equip/Tooling Handling/Pre	$\dashv$															
Material	$\vdash$															
Operator																
Offset/Setup																
Process																
Supplier																
Training			1							•						
Transport																
Unapproved																
						FA	ULT CAT	regory				<u> </u>				
Landi	ng Gear				General											
	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced				
	<del></del>	ot Concer	ntric	Щ	BOM/Route		Grain			Over/Under	tolerance	Set-up				
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	t	Temperature/Cure				
	_	nk/Ripple	/Wave	Ш	Burrs	_	Inspecti	on Incomplete/Unqualified		Part Lost/Mi	ssing	Weld				
	Cuffs			$\vdash$	Contamination		1	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled				
	Crushing				Countersink		1	ned/off center		Positioned W		_				
	Heat Trea				Cut Too Short		Mislabe			Power Loss/	Surge	Other				
	Inspectio		Tube		Drawing	_	Misread	1								
	Marks/Cl				Drill Holes	_	Off-set									
		Sequence		-	Finish	_	4	Calibration								
	Wave/⊺w	vist in Tub	e e	1 1	Fit/Function		IOut of 9	Sequence				1				